В

Required Date: 10/9/2009

Page 1

Tuesday, September 22, 2009 12:26:27 PM

Item ID:

D3001-1

Revision ID:

Doubler

QC:

Item Name: **Start Date:**

9/23/2009

Start Oty: 6.00

Req'd Oty: 6.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Date/99-22

Date:

Tooling:

SPC (Y/N):

Date: Date:

Start Run



Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp Stan
Draw Nbr	Revision Nbr								

D3001 Rev B

100

Waterjet

FLOW CNC Wateriet

6029 . 00

FLOW WATER JET

Memo

1-Cut as per Dwg D3001 Dwg Rev:

Prog Rev:

0.00

0.00

2-Deburr if necessary

110

OC

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

UB 9-11-6

B 9-11-6

Memo

Quality Control

Work Order ID 52349

Page 2

Tuesday, September 22, 2009 12:26:27 PM

Item ID:

D3001-1

В

Revision ID: Item Name:

Doubler

Start Date:

9/23/2009

Start Qty: 6.00

Accept

Setup Start

Stop

Required Date: 10/9/2009

Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling: Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Draw

Rev.

Date:

Start Run

Stop



Sequence ID/ **Work Center ID**

120

Quality Control

Operation **Description**

QC8- Inspect parts - second check

Memo

Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Draw

Number

130

Small Fab Small Fab

Small Fab

Memo

0.00

0.00

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

QC5- Inspect part completeness to step on W/O

0.00

0.00

Quality Control

140

Memo

B

Tuesday, September 22, 2009 12:26:27 PM

Item ID:

D3001-1

Revision ID: Item Name:

Doubler

Start Date:

9/23/2009

Start Otv: 6.00

Required Date: 10/9/2009 Reg'd Oty: 6.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: OC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Start Run



Stop

Sequence ID/ Work Center ID

150

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo

Memo

Set Up/ Run Hours

0.00

Draw Number

Draw Rev.

Date:

Plan Code Accept Qty

Reject Otv

Reject Number

Insp. Stamp

160

OC

Ouality Control

QC3- Inspect Part Finish

0.00

mo OIIII/10

170

Packaging

Identify as per dwg & Stock Location

Memo

0.00

0.00

9/11/10

Packaging

Work Order ID 52349

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Tuesday, September 22, 2009 12:26:27 PM

Item ID:

D3001-1

Revision ID:

В Doubler Item Name:

Required Date: 10/9/2009

Start Date:

9/23/2009

Start Otv: 6.00

Rea'd Otv: 6.00



Date:

Accept



Setup Start



Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Run Start

Stop

Sequence ID/

Work Center ID

180

Quality Control

Memo

OC21- Final Inspection - Work Order Release

0.00

0.00

Draw Number

Rev.

Date:

Plan Draw Code Accept **Qty**

Reject Qty

Reject Insp. Number Stamp

MF 09-11-10

Picklist Print

Tuesday, September 22, 2009 12:26:26 PM

Work Order ID: 52349

Parent Item:

D3001-1RevB

Parent Item Name: Doubler

Comments:



Start Date: 9/23/2009

Required Date: 10/9/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pic		Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	60.7600	4.4735	10.5		
1 1 1 1											B 9-11-1	,

5052-H32 .040 Sheet

	c209/11/06
M6061T65.040	•

Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	60.76		
101875	10		
102723	1		
104921	6.5		
106900	. 2		
107513	4.5		
109058	36.76		
13004			113004

Page 1

DART AEROSPACE LTD	Work Order:	57349
Description: Double	Part Number:	D.3001-1
Inspection Dwg: \(\cap \cap \cap \) \(\cap \) Rev: \(\bar{\mathbb{G}} \)		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First	Article	· [Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	4 .020	6.00	*			
17.00	4- 030	17.00	8			
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Measured by:	aD.	Audited by:		Prototype Approval:	N/A
Date:	- M-	Date:	09/4/06	Date:	N/A
Date.	1-11-160		0114700		

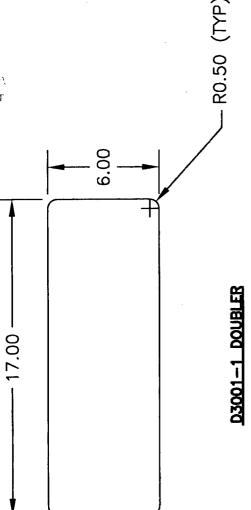
1	B	D-4-	Change	Revised by	Approved
- 1	Rev	Date	Change	KJ/JLM	
	Α		New Issue	TOTOLIN	L



DESIG	" P	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	(ED)	APPROVED , ,	DRAWING NO. RE	V. B
	Mek	#	D3001 SHEET 1	OF 1
DATE			TITLE	CALE
06.1	0.06		DOUBLER	1:5
Α		01.03.21	NEW ISSUE	
В		06.10.06	ADD BONDING PREP NOTE	

de 11.13

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER



1) MATERIAL: ALUMINUM 5052-H32/H34 SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.040)

OR ALUMINUM 6061-T6 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040) PREPARE FOR BONDING TO COMPOSITE STRUCTURE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 **PER DART QSI 006 4.10** 3

6

BREAK ALL SHARP CORNERS TO 0.010 MAX ALL DIMENSIONS ARE IN INCHES **466**

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